Date: User

Friday, 09/05/2008 1:45:20 PM

Julie Lecoca

Process Sheet

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

P.O. Number

This Issue

Prsht Rev.

First Issue

: 09/05/2008

: 36749A

: 39152A

: 10731

: NC

: //

S.O. No. :

Type

: SMALL /MED FAB

Material **Due Date**

: 05/06/2008

. D2324 REV. C

: STOP

: D23243

: N/A

: C

Qty:

20 Um:

Each

Written By

Previous Run

Checked & Approved By

Comment

: Est:

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M6061T6B0750X00750

Description:

6061-T6 Bar .75" x .75"

Comment: Qty.:

0.5565 f(s)/Unit Total: 11.1300 f(s)

M107387

6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

BAND SAW

Batch: M 102476 × 10 065

2.0

BAND SAW



Comment: BAND SAW

_Cut_blanks: <u>(0.75" x 0.75") x 5</u>.75" Long Bar

HAAS CNC VERTICAL MACHINING #

3.0

Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio D2324-3 and Dwg D2324

2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

INSPECT PARTS AS THEY COME OFF MACHINI

4.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #: Fault	Category:	_ NCR: Yes	No DQA	\:	_ Date: _	· .		
.	9			QA: N	N/C Closed	l:	_ Date:	· · · · · · · · · · · · · · · · · · ·		

	WORK ORDER NON-CONFORMANCE (NCR)								
	Corrective Action Section B				A	A			
Initial	Action Descr Chief Eng	ription Si	gn & Date '	Section C	Chief Eng	Approval QC Inspector			
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	Chief Eng	Initial Action Descr Chief Eng Chief Eng	Initial Action Description Sinch Chief Eng Chief Eng Chief Eng	Initial Chief Eng Chief Eng Sign & Date '	Initial Chief Eng Chief Eng Sign & Date Section C	Initial Chief Eng Chief Eng Sign & Date Chief Eng Chief			

Date: Friday, 09/05/2008 1:45:21 PM User: Julie Lecocq **Process Sheet** Drawing Name: STOP 2 Customer: CU-DAR001 Dart Helicopters Services Job Number: 39152A Part Number: D23243 Job Number: Seq. #: **Machine Or Operation:** Description: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER CO 7.0 QC3 **Comment: INSPECT ALODINE** PACKAGING RESOURCE# 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 FINAL INSPECTION/W/O BELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)		, 	
		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD

Work Order: 3915214

Description: Strut

Part Number: D2324-3

Inspection Dwg: D2324 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	Ø, 257°				
Ø0.191	+/-0.010	\$ 194"				
0.750	+/-0.010	,753°	/			
0.375	+/-0.010	375"				
1.875	+/-0.010	1.825"				
5.250	+/-0.010	5 2494				
5.625	+/-0.010	5,624"				
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Measured by: J. F	Audited by:	Took	Prototype Approval:	N/A
Date: 08/05/18	Date:	08/05/20	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	KJ/JLM	
В	06.03.08	Dwg Rev changed		KJ/JLM A	

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W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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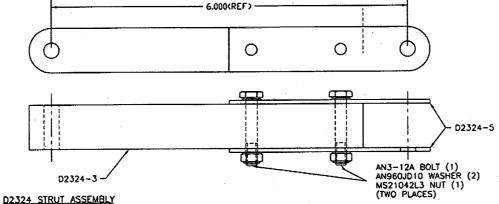
Part No:	PAR #:	_ Fault Category:	 NCR: Yes No	DQA:	Date: _	·· · · -
			QA: N/C	losed:	Date: _	

NCR:		·	WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC Section A	Corrective Action Section B				Varification	A	A		
	STEP		Initial Chief Eng	Action Descr Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto		
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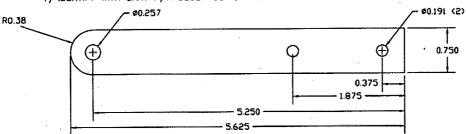


	DESIGN	DRAWN BY	DART AEROSPACE L			
1	B WILLIAMS			ANDA		_
1	CHECKED!	APPROVED_	DRAWING NO.		REV.	С
	#		D2324	SHEET	1 OF	1
	DATE		TITLE		SCAL	Ē
	04.12.14		STRUT			
	Α	94.11.08	NEW ISSUE			
	В	96.05.07	UPDATE MATERIALS			
	С	04.12.14	UPDATE NOTES			

RELEASED 04.12.16

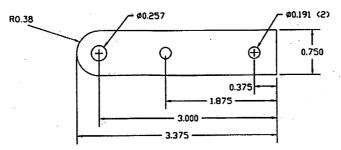


1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- -6061-T6/T651-BAR-(QQ-A-200/8)-0.75_X_0.75 -1) MATERIAL:
 - (REF DART SPEC. M6061T680.750X00.750)
- ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:
- POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
 - (REF DART SPEC. M304S16GA)
- POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

Dart Aerospace Ltd

	WORK ORDER CHANGES									
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr				

Part No:	PAR #:	Fault Category:	-	NCR: Yes No	DQA:	Date:	
,				QA: N/C	Closed:	Date:	

NCR:		We	ORK ORI	DER NON-CONFORMANC	E (NCR)								
		Description of NC		Corrective Action Section B	Verification		Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector					
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